

We claim:

1. A method of forming a waist band on an absorbent article comprising:
 - a) forming a stretchable front panel having a distal end, first and second side
5 edges, and a retracted length measured between said first and second side edges;
 - b) forming a stretchable back panel having a distal end, first and second side
edges, and a retracted length measured between said first and second side edges;
 - c) attaching an elastic band to at least one of said front and back panels, said
elastic band having first and second side edges and an outer end, said elastic band being
10 cantilevered outward from said distal end of said panel to which it is attached, and said
elastic band having a retracted length that is less than said retracted length of said panel
to which it is secured;
 - d) securing an absorbent assembly to said front and back panels, said absorbent
assembly including a liquid pervious bodyside liner, a liquid-impervious outer cover, and
15 an absorbent positioned therebetween;
 - e) folding said panel without said elastic band over both said other panel and said
elastic band so that said distal end of said panel without said elastic band is aligned
approximately even with said outer end of said elastic band; and
 - f) bonding said first and second side edges of said front panel, back panel and
20 elastic band together by a pair of seams to form an absorbent article having a waist
opening and a pair of leg openings.
2. The method of claim 1 wherein at least one of said front and back panels is
stretched to stop before said elastic band is attached thereto.
- 25 3. The method of claim 2 wherein said elastic band is stretched while being attached
to said panel.
4. The method of claim 3 wherein said elastic band is stretched to a greater extent
30 than said panel to which it is attached.
5. The method of claim 4 wherein said elastic band is stretched to a stop position and
then partially relaxed prior to attachment to one of said panels.
- 35 6. The method of claim 1 wherein said elastic band is secured to one of said panels
before said absorbent assembly is secured to both said front and back panels.

7. The method of claim 1 wherein said elastic band is attached to one of said panels after said absorbent assembly is secured to both said front and back panels.

5 8. The method of claim 1 wherein said elastic band is attached to one of said panels at the same time said absorbent assembly is secured to both said front and back panels.

9. The method of claim 1 wherein each of said front and back panels are stretched from between about 10% to about 500% prior to having said absorbent assembly
10 attached to them.

10. A method of forming a waist band on an absorbent article comprising:
a) forming a stretchable front panel having a distal end, first and second side edges, and a retracted length measured between said first and second side edges;
15 b) forming a stretchable back panel having a distal end, first and second side edges, and a retracted length measured between said first and second side edges;
c) attaching an elastic band to each of said front and back panels, each elastic band having first and second side edges and an outer end, each of said elastic bands being cantilevered outward from said distal end of said panel to which it is attached, and
20 each of said elastic bands having a retracted length that is less than said retracted length of said panel to which it is secured;
d) securing an absorbent assembly to said front and back panels, said absorbent assembly including a liquid pervious bodyside liner, a liquid-impervious outer cover, and an absorbent positioned therebetween, said absorbent assembly being positioned
25 between said distal ends of said front and back panels;
e) folding one of said panels over said other panel so that said outer ends of each of said elastic bands are aligned approximately even; and
f) bonding said first and second side edges of said front panel, back panel and elastic bands together by a pair of seams to form an absorbent article having a waist
30 opening and a pair of leg openings.

11. The method of claim 10 wherein each of said elastic bands extends outward beyond said distal edge of said panel to which it is attached by a distance of from between about 1 millimeter to about 75 millimeters.

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12. The method of claim 11 wherein each of said elastic bands extends outward beyond said distal edge of said panel to which it is attached by a distance of at least about 10 millimeters.
- 5 13. The method of claim 10 wherein said front panel, said back panel and each of said elastic bands has a force of retraction, and said force of retraction in each of said elastic bands is greater than said force of retraction in either of said front panel and said back panel.
- 10 14. The method of claim 10 wherein each of said front and back panels are stretched from between about 50% to about 300% prior to having said absorbent assembly attached to them.
- 15 15. The method of claim 10 wherein each of said front and back panels are stretched from between about 75% to about 270% prior to having said absorbent assembly attached to them.
16. A method of forming a waist band on an absorbent article comprising:
a) forming a stretchable front panel having a distal end, first and second side edges, an outside edge and a retracted length measured between said first and second side edges;
b) forming a stretchable back panel having a distal end, first and second side edges, an outside edge and a retracted length measured between said first and second side edges;
c) attaching an elastic band to said outside surface of each of said front and back panels, each of said elastic bands having first and second side edges and an outer end, each of said elastic bands being cantilevered outward from said distal end of said panel to which it is attached, and each of said elastic bands having a retracted length that is less than said retracted length of said panel to which it is secured;
d) securing an absorbent assembly to said front and back panels, said absorbent assembly including a liquid pervious bodyside liner, a liquid-impervious outer cover, and an absorbent positioned therebetween, said absorbent assembly being positioned between said distal ends of said front and back panels;
e) folding one of said panels over said other panel so that said outer ends of each of said elastic bands are aligned approximately even; and
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f) bonding said first and second side edges of said front panel, back panel and elastic bands together by a pair of seams to form an absorbent article having a waist opening and a pair of leg openings, and said elastic bands creating a snug fit at said waist opening.

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17. The method of claim 16 wherein each of said elastic bands extends outward beyond said distal edge of said panel to which it is attached by a distance of from between about 1 millimeter to about 75 millimeters.

10 18. The method of claim 17 wherein each of said elastic bands has a retracted length that is at least 2% less than the retracted length of said panel to which it is secured.

19. The method of claim 16 wherein said absorbent assembly is secured to both said front and back panels before said elastic bands are secured to said front and back panels.

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20. The method of claim 16 wherein each of said front and back panels are stretched from between about 50% to about 300% prior to having said elastic band attached to one of said panels.